

Work Order ID 86539***86539***

Page 1

Wednesday, July 04, 2012 4:10:02 PM

Item ID: D3916-041

Accept:

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly

Start Date: 7/4/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *12-07-04*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3916

A

100

0.00

100

Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on
side of tube when bending***
3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605

(6) SMD 12-07-16

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

QC 12-07-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86539

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86539

Page 2

Item ID: [D3916-04]

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N900040100

Setup Start ***NS1***

Revision ID:

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Item Name: Rib Assembly

Start Date: 7/4/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

107

Weld per dwg A/R S.S. rod Batch: M121602 0.00

107

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916
2- grind welds flush

pl / cc 12-7-12

110

QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

0.00

Quality Control

DAS 16 7/10/12

6x

12-07-12

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

0.00

Quality Control

DAS 16 7/10/12

Dart Aerospace Ltd

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



140

QC

Memo

0.00

Quality Control

 12-07-1912/17/23 ME
12-07-20

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, July 04, 2012 4:10:02 PM

Page 1

Work Order ID: 86539

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 7/4/2012

Required Date: 7/11/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	170.0000	7	42		12-7-18	

Location

Loc Qty

Loc Code

WA

163

79213

1

83464

162

WA005

7

66489

1

82785

6

M304TS0.750W.049

Purchased

No

304 SQ Tube .75x.75x.049W

100

f

158.6697

4.166

26,311,579

12-07-16

Location

Loc Qty

Loc Code

MAT017

37.756337

121898

37.756337

MAT018

119.8508959

119147

2

119643

3.30639585

121439

16.8353

122201

97.7092

WA034

1.0625

121087

1.0625

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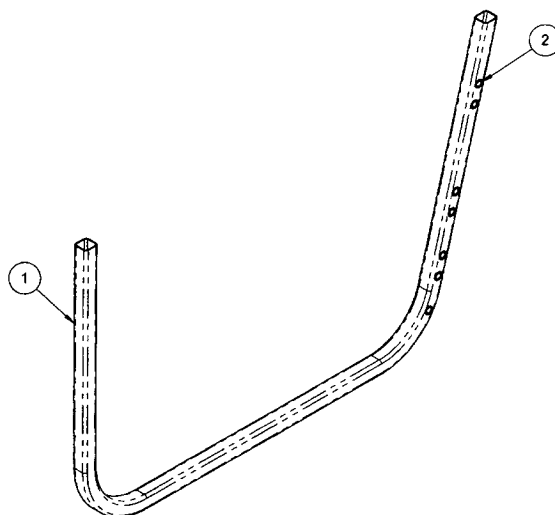
W/O:		WORK ORDER CHANGES					
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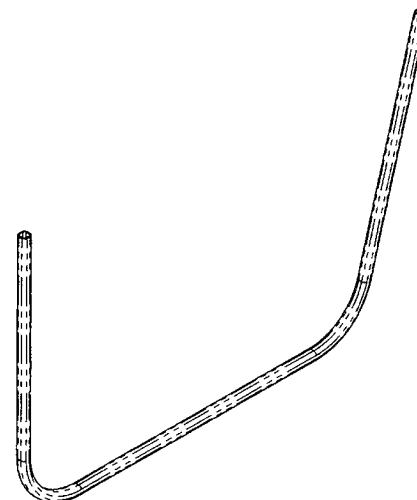
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ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

#86539

OK 10.12.21
 UNDER REVIEW
 ADDITION OF HOLE + BUSHING
 ON D3916-041 RIBS.

RELEASED
 2010-03-12
 JWP

A		NEW ISSUE		JPH		10.03.04	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A		SHEET 1 OF 4	
DRAWN	JPH						
CHECKED	[Signature]	DRAWING NO.		REV. A			
MFG. APPR.	[Signature]	D3916					
APPROVED	[Signature]	TITLE		SCALE			
DE APPR.	[Signature]	RIB ASSY, 350 BASKET		NTS			
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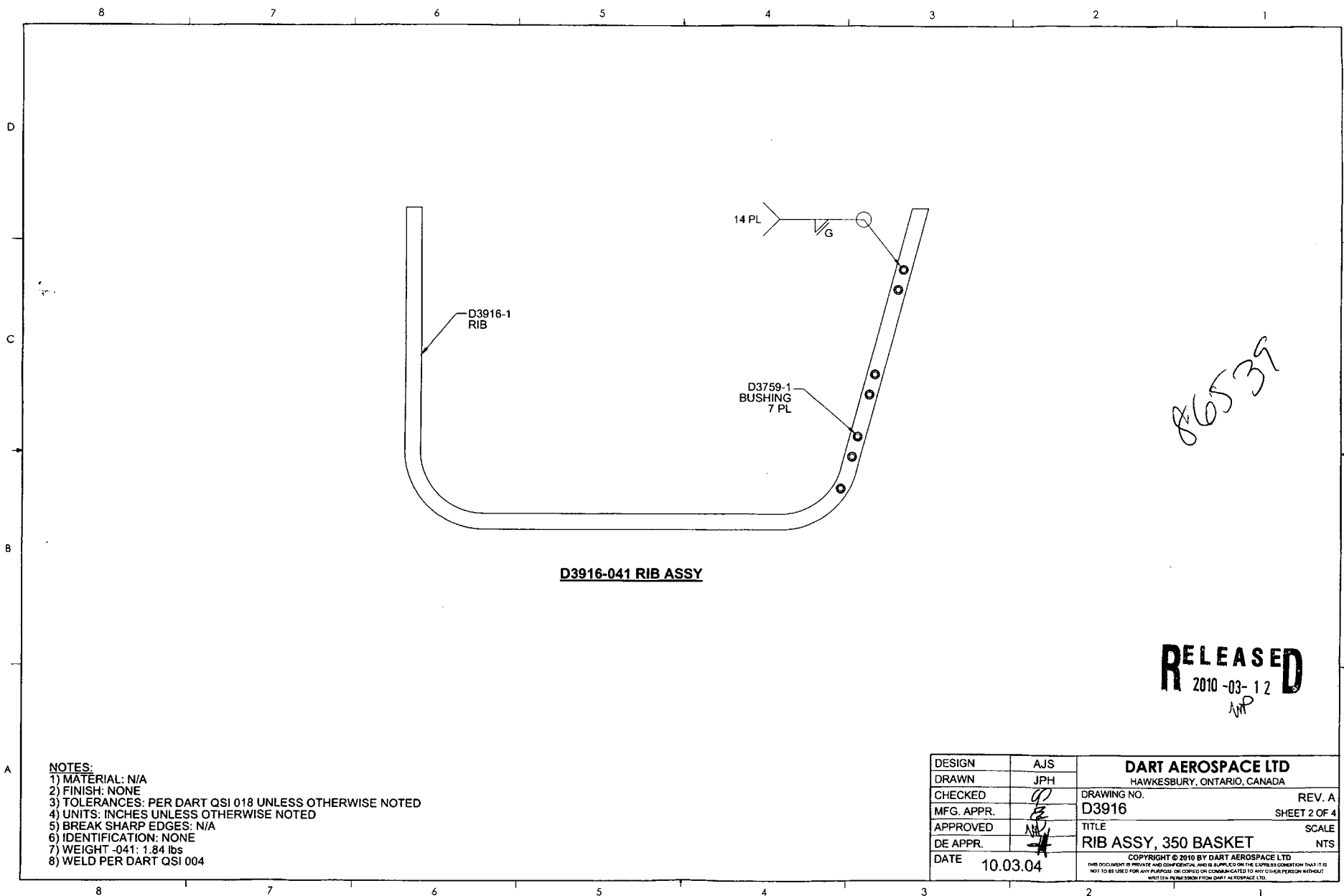
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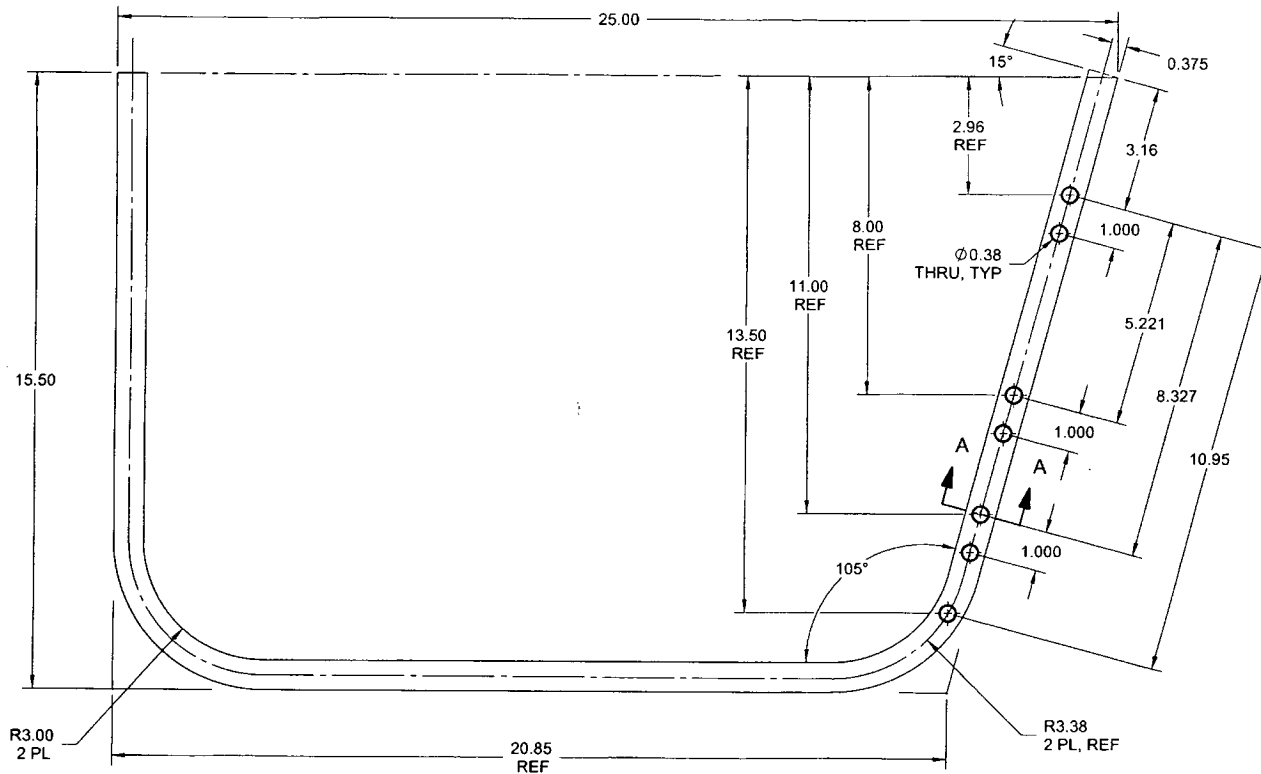
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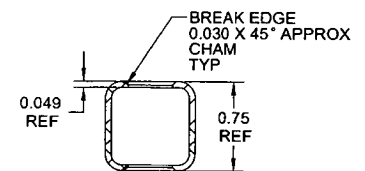
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NOTE: Date & initial all entries



9 D3916-1 RIB







SECTION A-A

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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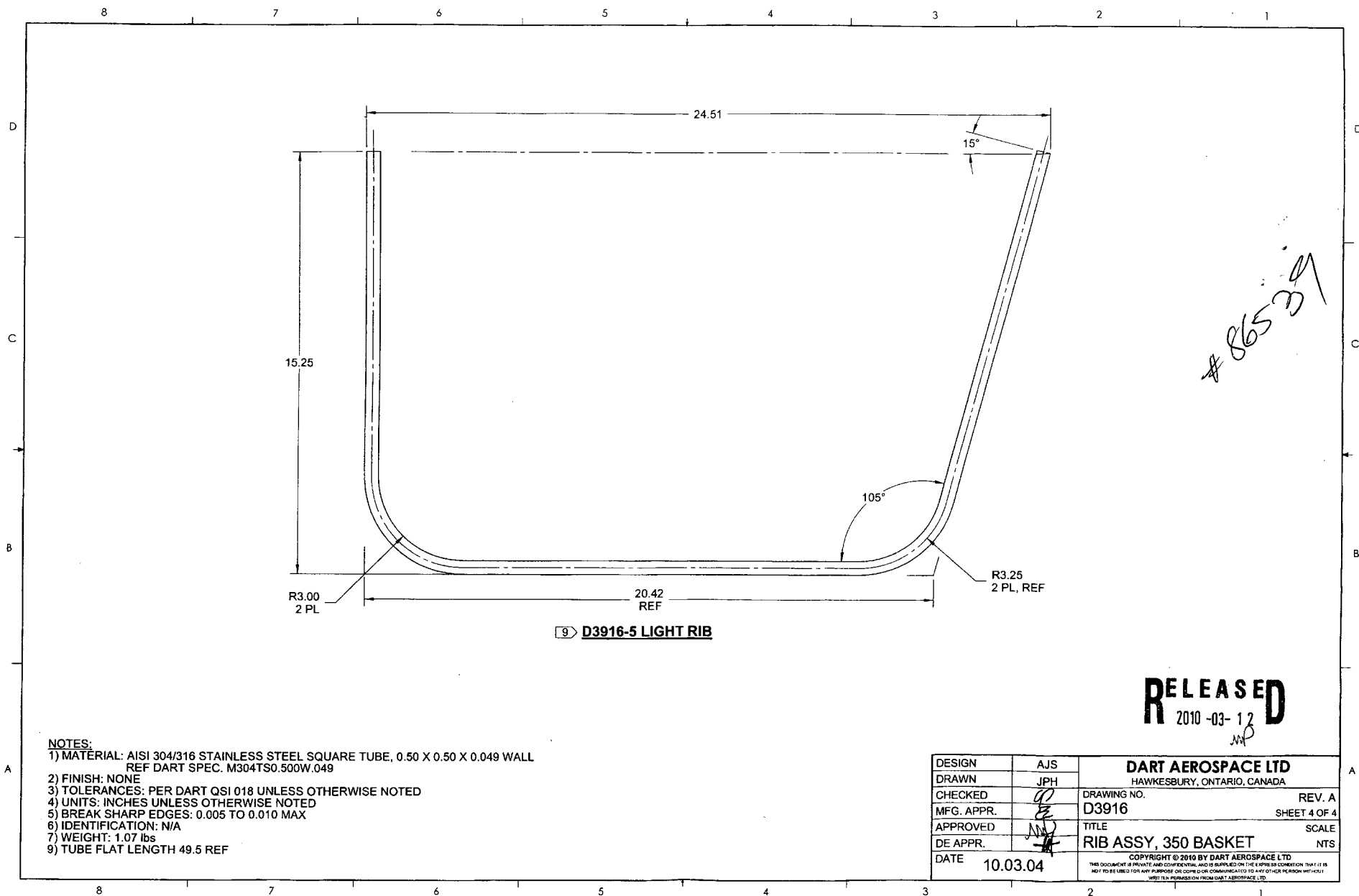
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries







9 D3916-5 LIGHT RIB

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
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